

Date: Wednesday, 17/10/2007 1:28:22 PM  
 User: Linda Lacelle

## Process Sheet

|                                    |                                     |                           |             |
|------------------------------------|-------------------------------------|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> :     | FWD X-TUBE  |
| <b>Job Number</b> :                | 35185                               |                           |             |
| <b>Estimate Number</b> :           | 10006                               |                           |             |
| <b>P.O. Number</b> :               | N/A                                 | <b>Part Number</b> :      | D2889       |
| <b>This Issue</b> :                | 17/10/2007                          | <b>S.O. No.</b> :         | N/A         |
| <b>Prsht Rev.</b> :                | NC                                  | <b>Drawing Number</b> :   | D2889 REV B |
| <b>First Issue</b> :               | N/A                                 | <b>Project Number</b> :   | N/A         |
| <b>Previous Run</b> :              | 33025                               | <b>Drawing Revision</b> : | B           |
|                                    |                                     | <b>Material</b> :         | N/A         |
| <b>Written By</b> :                |                                     | <b>Due Date</b> :         | 24/10/2007  |
| <b>Checked &amp; Approved By</b> : |                                     | <b>Qty:</b>               | 1           |
| <b>Comment</b> :                   | Est Rev:A New Issue 05-10-25 JLM    | <b>Um:</b>                | Each        |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |          |                    |
|-----|----------|--------------------|
| 1.0 | D6005180 | Crosstube material |
|-----|----------|--------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

|     |             |               |        |
|-----|-------------|---------------|--------|
| Qty | Part number | Description   | Batch  |
| 1   | D2889       | Fwd Crosstube | B23963 |

|     |         |                 |
|-----|---------|-----------------|
| 2.0 | BENDING | BENDING MACHINE |
|-----|---------|-----------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 7-10-18

|     |                |                         |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

JA-10-22 ①

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1  
 Inside and outside of tube

N/A

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DD Date: 07/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 17/10/2007 1:28:22 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 35185

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 34164

A-1022

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Don't

Job Completion



U 07-10.23

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

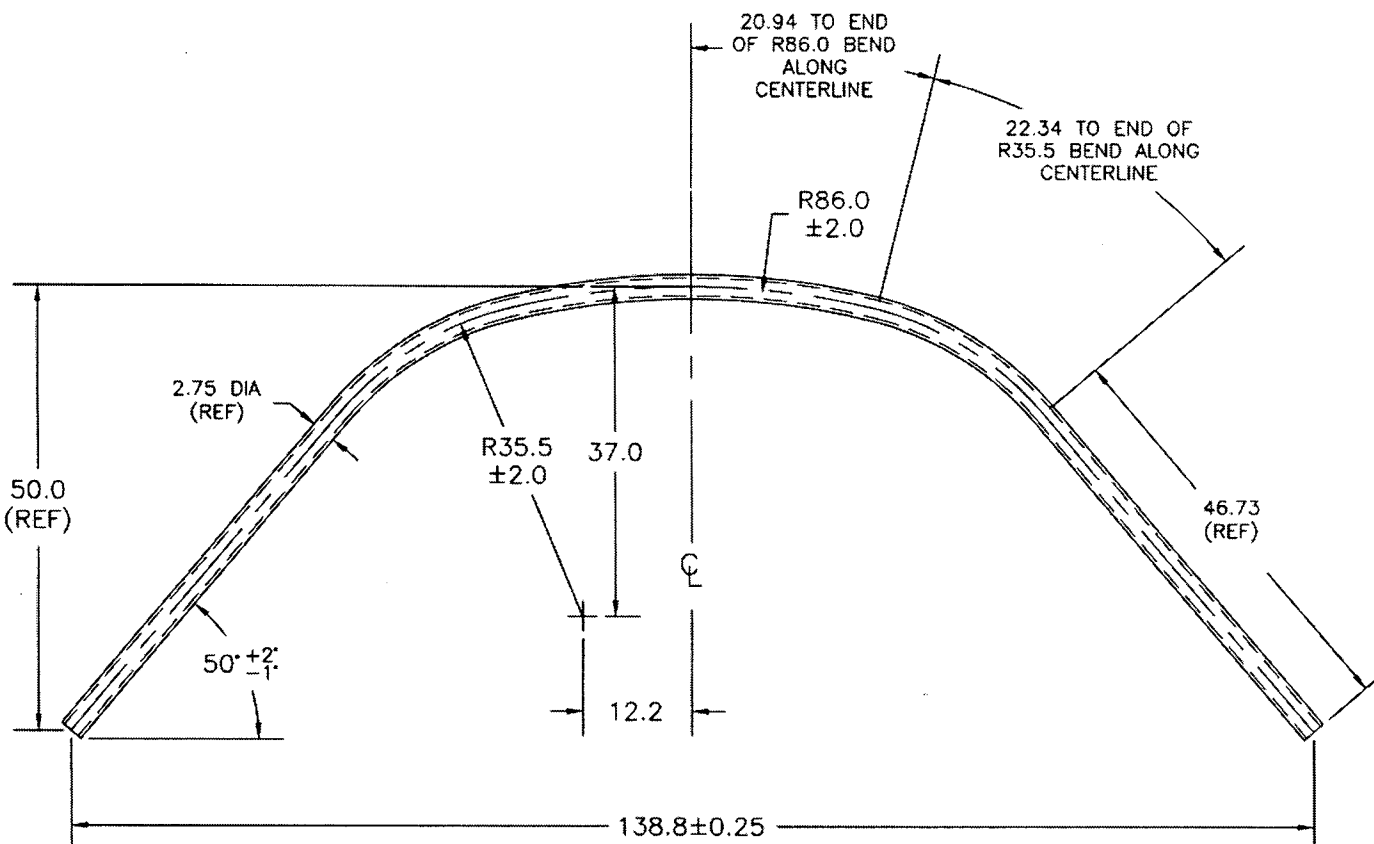
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



RELEASED  
02.10.28

| DESIGN                    | DRAWN BY                   | DART AEROSPACE LTD                |
|---------------------------|----------------------------|-----------------------------------|
| CHECKED <i>[initials]</i> | APPROVED <i>[initials]</i> | HAWKESBURY, ONTARIO, CANADA       |
| DATE                      | DRAWING NO.                | REV. B                            |
| 02.10.18                  | D2889                      | SHEET 1 OF 1                      |
|                           | TITLE                      | SCALE                             |
|                           | FWD CROSS TUBE             | 1:20                              |
| A                         | 99.05.21                   | NEW ISSUE                         |
| B                         | 02.10.18                   | ADD TANGENT LENGTHS; CHANGE NOTES |



#### NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (Ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

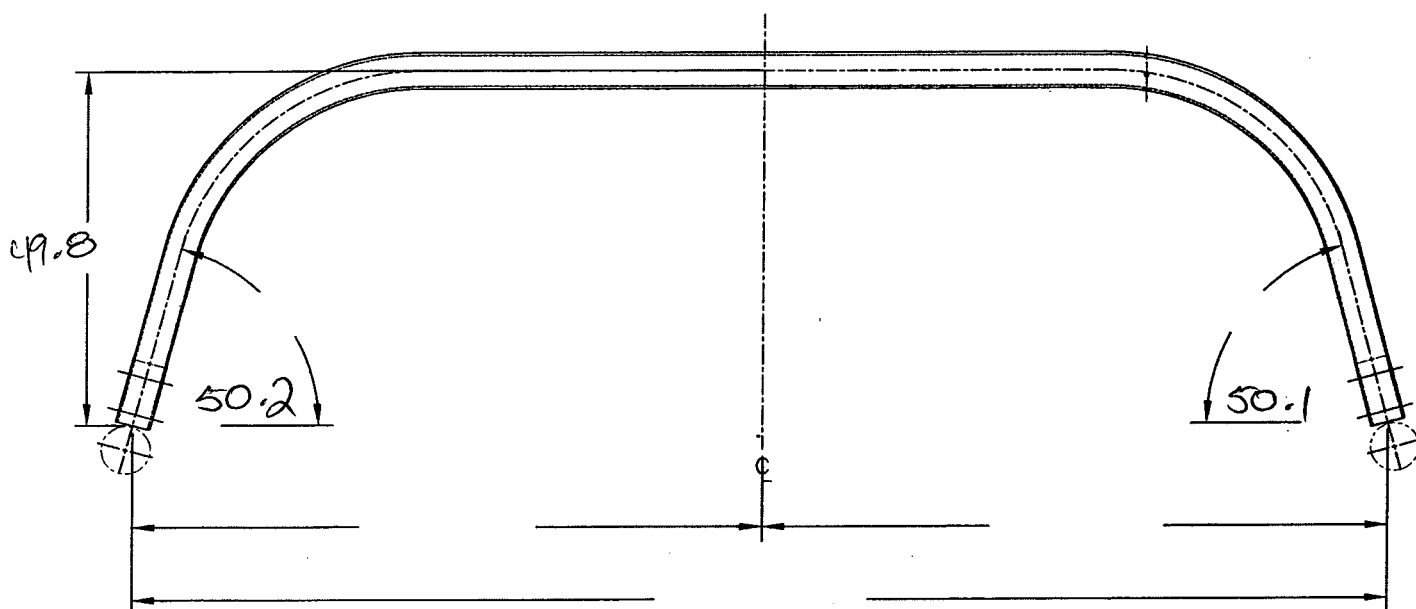
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

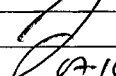
**NOTE:** Date & initial all entries

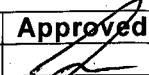
|                                   |               |                           |
|-----------------------------------|---------------|---------------------------|
| <b>DART AEROSPACE LTD</b>         |               | <b>Work Order:</b> 35185  |
| <b>Description:</b> Crosstube Fwd |               | <b>Part Number:</b> D2889 |
| <b>Inspection Dwg:</b> D2889      | <b>Rev:</b> B | <b>Page 1 of 1</b>        |

| Required Dimension | Min    | Max    |
|--------------------|--------|--------|
| Height             | 49.875 | 50.125 |
| 1/2 Span           | 69.275 | 69.525 |
| Angle              | 49     | 52     |
| Total Span         | 138.55 | 139.05 |



| Comments                             |
|--------------------------------------|
| Tube is good for 1205-576-105 B34164 |
|                                      |
|                                      |

|                 |   |
|-----------------|---|
| QC15 Inspection |  |
| Date            |   |
|                 | 07-10-22  |

| Rev | Date     | Change    | Revised by | Approved  |
|-----|----------|-----------|------------|---|
| A   | 07.02.06 | New Issue | KJ/JM      |  |

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries